

Date: Wednesday, 25/03/2009 1:09:49 PM
User: Jean-Luc Menard

Process Sheet

| | |
|---|---------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : CUFF |
| Job Number : 46705 | |
| Estimate Number : 13023 | |
| P.O. Number : | Part Number : D36601 |
| This Issue : 25/03/2009 S.O. No. : | Drawing Number : D3660 REVB |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : MACHINED PARTS | Drawing Revision : B |
| Previous Run : 44455 | Material : |
| Written By : <u>JLM 09.03.25</u> | Due Date : 01/04/2009 Qty: 6 Um: Each |
| Checked & Approved By : | |
| Comment : est rev A new issue 07.09.19 EC verified by:JLM Est Rev:B 08-04-07 chg to revB DD verified by: | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|----------|---------------------|
| 1.0 | D6008180 | Crosstube Extrusion |
|-----|----------|---------------------|



Comment: Qty.: 0.6384 Each(s)/Unit Total: 3.8304 Each(s)
Crosstube extrusion

Batch: B40271 + 0.5 extra 3.84

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
Cut blank 7.300 " long

SA 09/03/25 (6)

| | | |
|-----|--------------|--------------|
| 3.0 | DOOSAN LATHE | DOOSAN LATHE |
|-----|--------------|--------------|



Comment: DOOSAN LATHE
1-Turn as per folio FA 708 & DWG D3660,
FOLIO REV: N/A
DWG REV: 6

2-Debur as required

PTO (6) 09/04/01

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

09/04/01 (6)

| | | |
|-----|-----|--------------|
| 5.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

SP 09/04/01 (6)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CUFF

Job Number: 46705

Part Number: D36601

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

95

09-04-02

(X6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-04-02 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST142

09/04/08 (6)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



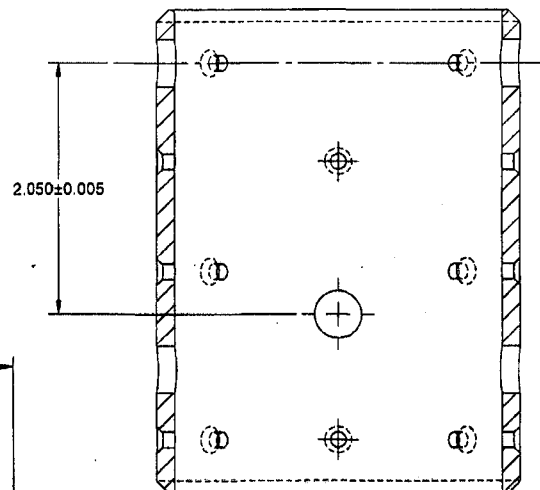
Comment: FINAL INSPECTION/W/O RELEASE

09/04/08
mk
09-04-08

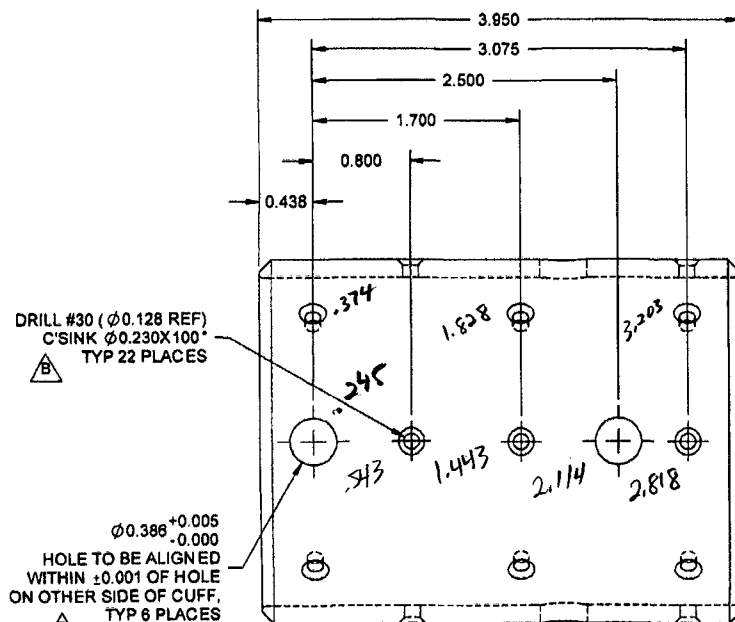
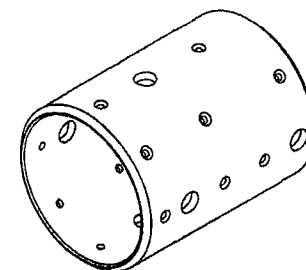
Job Completion



064
193

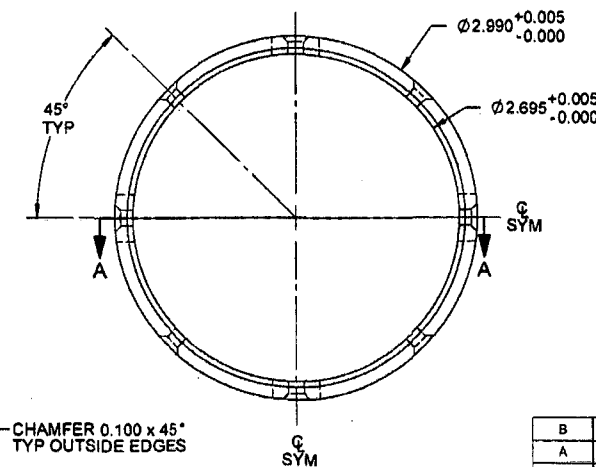


SECTION A-A
R0.032 TYP
INSIDE EDGES



DRILL #30 (Ø0.128 REF)
C/SINK Ø0.230X100*
TYP 22 PLACES

Ø0.386^{+0.005}
-0.000
HOLE TO BE ALIGNED
WITHIN ±0.001 OF HOLE
ON OTHER SIDE OF CUFF
TYP 6 PLACES



CHAMFER 0.100 x 45°
TYP OUTSIDE EDGES

D3660-1 CUFF

46705

NOTES:

- 1) MATERIAL: 7075-T6/T8511 SEAMLESS TUBE (WWW-T-700/7 OR QQ-A-225/9 OR QQ-A-200/11)
(CAN MAKE FROM D6006, D6008, OR D6009)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.50 lbs

| B | ADD Ø0.128 & Ø0.386 HOLES (B8) | CP | 08.03.03 |
|------------|--------------------------------|----|----------|
| A | NEW ISSUE | CP | 27.07.07 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | IP | | |
| DRAWN | EP | | |
| CHECKED | RF | | |
| MFG. APPR. | JS | | |
| APPROVED | JS | | |
| DE APPR. | JS | | |
| DATE | 08.03.03 | | |

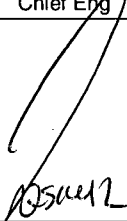
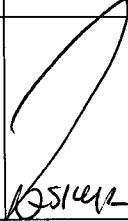
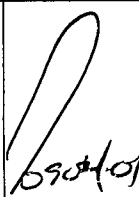
DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA
DRAWING NO. D3660
TITLE CUFF
REV. B
SHEET 1 OF 1
SCALE NTS

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NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT
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| W/O: 46705 | | WORK ORDER CHANGES | | | | | |
|------------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: D 3660-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 09/04/09

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: 46705 | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------------|------|--|--|---------------------------------|----------------|---------------------------|--|--|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 09/04/09 | 2.0 | Vibration inside bore. Result of difficulty chip breaking on inside diameter machining. B.C. process |  | Scrap piece + replace. Qty 1 | 09/04/09 | E 09/04/09 |  |  |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|---------------------------|---------------|----------------------------|
| DART AEROSPACE LTD | | Work Order: 46705 |
| Description: CUFF | | Part Number: D 3601 |
| Inspection Dwg: | Rev: B | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|----------------|------------------|--------|--------|----------------------|----------|
| 3.950 | +/- .010 | 3.950 | / | | | |
| .438 | +/- .010 | .438 | / | | | |
| 3.075 | +/- .010 | 3.075 | / | | | |
| 2.500 | +/- .010 | 2.500 | / | | | |
| 1.700 | +/- .010 | 1.700 | / | | | |
| .800 | +/- .010 | .800 | / | | | |
| .128 Ø | + .005 - 0.001 | .128 | / | | | |
| .230 Ø X | + .006 - .001 | .230 | / | | | |
| 100° | +/- 1/2° | 100° | / | | | |
| .386 | + .005 - 0.0 | .386 | / | | | |
| 2.050 | +/- .005 | 2.050 | / | | | |
| 12.032 | +/- .00 | 12.022 | / | | | |
| 45° | +/- 1/2° | 45° | / | | | |
| 2.990 | + .005 - 0.0 | 2.990 | / | | | |
| 2.695 | + .005 - 0.0 | 2.695 | / | | | |
| .100 X | +/- .010 | .100 | / | | | |
| 45° | +/- 1/2° | 45° | / | | | |
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|---------------------------------|
| Measured by: [Signature] |
| Date: 09/04/01 |

| |
|--------------------------------|
| Audited by: [Signature] |
| Date: 09/04/01 |

| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| A | | New Issue | KJ/JLM | |